

INTUITIVE

SURGICAL

Manufacturing Process InstructionsPROCESS I.D.
CABLE
TENSIONINGOPERATION #
DUAL JAW 13

TQC



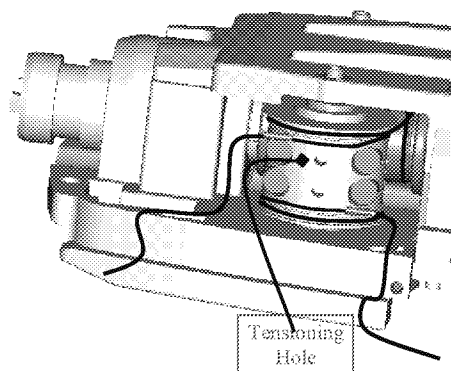
WORK CONTENT



VERIFY

GENERAL CABLE TENSIONING METHOD

1. ■ Install the unit on an input nest with the appropriate wrist nest.
2. △ Verify that each wrist cable is on the correct idler and clamping pulley.
3. △ Verify that each crimp is seated in the clamping pulley counterbore.
4. △ Verify that each roll cable is in the clamping and roll pulley grooves.
5. △ Verify that roll axis is locked at zero and that each roll crimp is seated in the counterbores.
6. ■ Insert the cable tensioning tool into the tensioning hole on a Clamping Pulley. While holding the tensioning tool in one hand, loosen both Screws on the Pulley until the Pulley turns freely on the Input Shaft.



7. ■ Move the tensioning tool towards the crimp until the correct tension is reached (indicated by the marks on the tensioning tool). While holding the correct tension, tighten one screw, then the other.
8. ■ Repeat tensioning process on all clamping pulleys. Tension each cable to the marks specified on page 2.

9. ● Visually verify that each set of upper and lower Clamping Pulleys contact each other--there should be no gap between them.

FIND	PART #	DESCRIPTION	QTY
EFT	833325 833800	Input Nest	-
EFT	See BOM	Wrist Nest	-
EFT	833916	Tensioning Tool, Beam Style	-
EFT	833054	40 in/oz Torque Driver	-
ENGINEER		DATE	
MPI # 838012		REV C	
		PAGE 1 OF 2	

UNITED STATES DISTRICT COURT
NORTHERN DISTRICT OF CALIFORNIA**TRIAL EXHIBIT 622**

Case No. 3:21-cv-03496-AMO

Date Entered _____

By _____

Deputy Clerk

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PROCESS I.D.
CABLE
TENSIONINGOPERATION #
DUAL JAW 13 TQC WORK CONTENT VERIFY

FIND	PART #	DESCRIPTION	QTY
A	330072	Washer, .095 I.D. X .125 O.D., .010 T.	6
EFT	833025	Input Shaft Swager	-
EFT	833370	EFT, INPUT SHAFT SWAGE TOOL	-

ENGINEER

DATE

MPI #

838012

REV

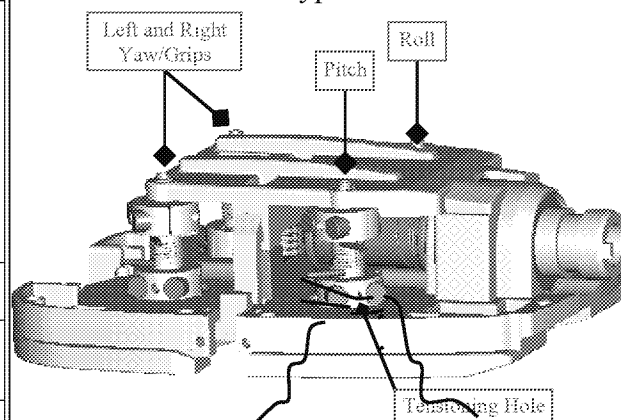
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Manufacturing Process Instructions

- 10. ■** Tension Roll axis to the **second (outer) marks** on every instrument type.



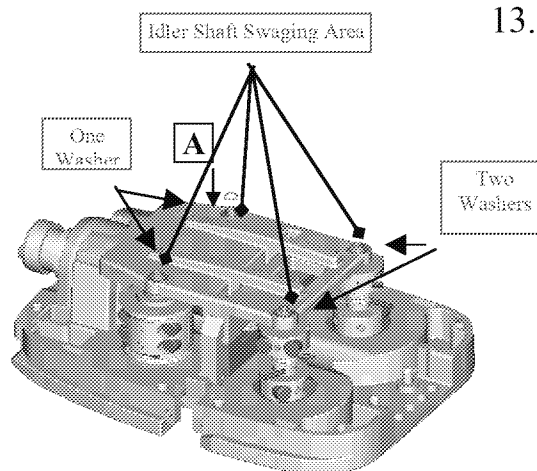
- 11a. ■ Scissors and Clip Applier Only**

Tension **Pitch** and **Yaw/Grip** to the **first (inner)** marks on the Tensioning Tool

- 11b. ■ Graspers (Forceps, Needle Drivers) Only**

Tension **Pitch** and **Yaw/Grip** to the **second (outer)** marks on the Tensioning Tool.

- 12. ■** Clip excess cable flush with the back of each Crimp.



- 13. ■** Insert two Washers onto the Yaw/Grip Input Shafts and one Washer onto the pitch and roll Input Shafts. Perform swage operation on each Input Shaft .

- 14. ●** Verify visually that the tops of all of the Input Shafts have been mushroomed over.